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(58) Field of Search

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(54) **Detergent compositions**

(57) A detergent composition suitable for use in laundry or dish washing methods comprises:

(a) a hard acid cationic component; and

(b) a hard base polymeric component,

the ratio of cationic component to hard base polymeric component being from 10:1 to 1:3.

The cationic component may be a quaternary ammonium compound.

The polymeric component may be an acrylic or maleic polymer.

The composition contains less than 20% by weight of phosphate.

**2318363****Detergent compositions****Technical field**

The present invention relates to detergent compositions containing a cationic component and a hard base polymeric component, which are suitable for use in laundry and dishwashing methods.

**Background to the invention**

The satisfactory removal of greasy soils/stains, that is soils/stains having a high proportion of triglycerides or fatty acids, is a challenge faced by the formulator of detergent compositions for use in laundry and dish washing methods. Surfactant components have traditionally been employed in detergent products to facilitate the removal of such greasy soils/stains. In particular, surfactant systems comprising cationic surfactants are known for use in greasy soil/stain removal.

For example, EP-B-21,491 discloses detergent compositions containing a nonionic/cationic surfactant mixture and a builder mixture comprising aluminosilicate and polycarboxylate builder. The cationic surfactant may be a cationic ester. Improved particulate and greasy/oily soil removal is described.

It is known that the combination of these cationic surfactants with a hard base polymeric component will improve the removal of greasy/oily soil removal. The combination of these cationic surfactants with

nonionic surfactants in compositions designed for particulate soil removal is also described.

Polymeric compounds are also known components of detergent compositions. They are generally incorporated in detergent compositions as soil suspension agents.

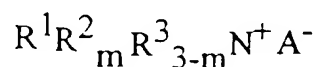
It has been found that the stain and greasy soil removal properties of detergent compositions incorporating both a cationic component and a polymeric component are surprisingly enhanced when the two components are used within a specific ratio. The use of the combination of components within the specific ratio also enables the overall quantity of one or both components to be reduced whilst achieving the same, or improved cleaning performance.

All documents cited in the present description are, in relevant part, incorporated herein by reference.

### Summary of the Invention

A detergent composition of the present invention comprises a hard acid cationic component and up to 1.7% by weight total detergent composition of hard base polymeric component, and wherein the ratio of hard acid cationic component to hard base polymeric component is from 10:1 to 1:3, the composition comprising less than 20% by weight phosphate component.

In a preferred aspect of the invention, the ratio of hard acid cationic component to hard base polymeric component is from 5:1 to 1:2. The ratio may be 5:1 to 1:1. In a further preferred aspect said hard acid cationic



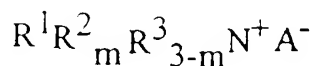
wherein  $R^1$  represents a C<sub>6-24</sub> alkyl or alkenyl group or a C<sub>6-12</sub> alkaryl group, each  $R^2$  independently represents a  $(C_n H_{2n} O)_x R^4$  group where n is 1 to 4 and x is from 1 to 14 and  $R^4$  represents hydrogen (preferred), methyl or ethyl, the sum total of  $C_n H_{2n} O$  groups is  $R_m^2$  being from 1 to 14, each  $R^3$  group independently represents a C<sub>1-12</sub> alkyl or alkenyl group, an aryl group or a C<sub>1-6</sub> alkaryl group, m is 1, 2 or 3, and A is a counterion providing electrical neutrality.

### Detailed description of the invention

#### Hard Acid Cationic Component

An essential element of the detergent compositions of the invention is a cationic component. Generally, the hard acid cationic component comprises a quaternary ammonium compound, preferably a surfactant. The cationic component is preferably present at a level from 0.5% to 20.0%, more preferably from 0.1% to 10%, most preferably from 1.0% to 5.0% or even below 1.5% by weight of the detergent composition.

Any quaternary ammonium cationic surfactant may be used however, according to a preferred aspect of the invention, the cationic component comprises a surfactant selected from compounds of the formula.



wherein  $R^1$  represents a C<sub>6-24</sub> alkyl or alkenyl group or a C<sub>6-12</sub> alkaryl group, each  $R^2$  independently represents a  $(C_n H_{2n} O)_x R^4$  group where n is 1 to 4 and x is from 1 to 14 and  $R^4$  represents hydrogen (preferred), methyl or ethyl, the sum total of  $C_n H_{2n} O$

groups is  $R^2_m$  being from 1 to 14, each  $R^3$  group independently represents a  $C_{1-12}$  alkyl or alkenyl group, an aryl group or a  $C_{1-6}$  alkaryl group,  $m$  is 1, 2 or 3, and  $A$  is a counterion providing electrical neutrality.

Particularly preferred surfactants have  $R^2$  equal to  $-CH_2CH_2OH$ , each  $R^3$  independently selected from  $C_{1-4}$  alkyl, preferably methyl and  $m$  is 1 or 2. Preferably  $R^1$  is a linear  $C_{6-14}$  alkyl group.  $C_{8-10}$  alkyl groups have been found to be particularly useful.  $C_{12-14}$  alkyl groups have also been found to be particularly useful.

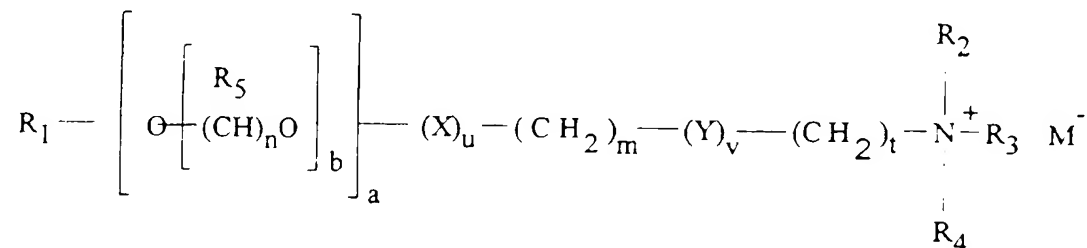
Preferably the cationic component is a monoquaternary ammonium compound.

The cationic component surfactant of the present invention is preferably a water dispersible, compound having surfactant properties.

The cationic component may comprise a cationic ester surfactant. Suitable cationic ester surfactants, including choline ester surfactants, have for example been disclosed in US Patents No.s 4228042, 4239660 and 4260529.

In preferred cationic ester surfactants the ester linkage (i.e.  $-COO-$ ) and cationically charged group of the cationic ester are separated from each other in the surfactant molecule by a spacer group consisting of a chain comprising at least three atoms (i.e. of three atoms chain length), preferably from three to eight atoms, more preferably from three to five atoms, most preferably three atoms. The atoms forming the spacer group chain are selected from the group consisting of carbon, nitrogen and oxygen atoms and any mixtures thereof, with the proviso that any nitrogen or oxygen atom in said chain connects only with carbon atoms in the chain. Thus spacer groups having, for example,  $-O-O-$  (i.e. peroxide),  $-N-N-$ , and  $-N-O-$  linkages are excluded, whilst spacer groups having, for example  $-CH_2-O-CH_2-$  and  $-CH_2-NH-CH_2-$  linkages are included. In a preferred aspect the

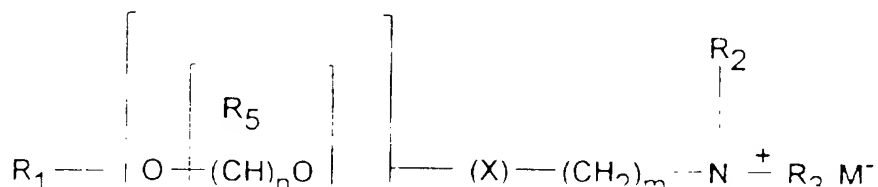
Preferred cationic ester surfactants are those having the formula:



wherein  $R_1$  is a  $C_5$ - $C_{31}$  linear or branched alkyl, alkenyl or alkaryl chain or  $M^-$ .  $N^+(R_6R_7R_8)(CH_2)_s$ ;  $X$  and  $Y$ , independently, are selected from the group consisting of  $COO$ ,  $OCO$ ,  $O$ ,  $CO$ ,  $OCOO$ ,  $CONH$ ,  $NHCO$ ,  $OCONH$  and  $NHCOO$  wherein at least one of  $X$  or  $Y$  is a  $COO$ ,  $OCO$ ,  $OCOO$ ,  $OCONH$  or  $NHCOO$  group;  $R_2$ ,  $R_3$ ,  $R_4$ ,  $R_6$ ,  $R_7$ , and  $R_8$  are independently selected from the group consisting of alkyl, alkenyl, hydroxyalkyl and hydroxy-alkenyl groups having from 1 to 4 carbon atoms and alkaryl groups; and  $R_5$  is independently  $H$  or a  $C_1$ - $C_3$  alkyl group; wherein the values of  $m$ ,  $n$ ,  $s$  and  $t$  independently lie in the range of from 0 to 8, the value of  $b$  lies in the range from 0 to 20, and the values of  $a$ ,  $u$  and  $v$  independently are either 0 or 1 with the proviso that at least one of  $u$  or  $v$  must be 1; and wherein  $M$  is a counter anion.

Preferably  $M$  is selected from the group consisting of halide, methyl sulfate, sulfate, and nitrate, more preferably methyl sulfate, chloride, bromide or iodide.

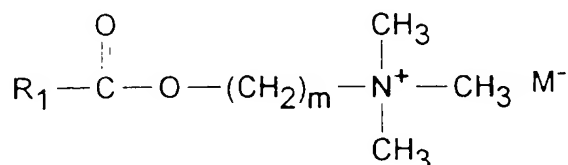
The cationic ester surfactant may be selected from those having the formula:



wherein  $R_1$  is a  $C_5$ - $C_{31}$  linear or branched alkyl, alkenyl or alkaryl chain; X is selected from the group consisting of COO, OCO, OCOO, OCONH and NHCOO;  $R_2$ ,  $R_3$ , and  $R_4$  are independently selected from the group consisting of alkyl and hydroxyalkyl groups having from 1 to 4 carbon atoms; and  $R_5$  is independently H or a  $C_1$ - $C_3$  alkyl group; wherein the value of n lies in the range of from 0 to 8, the value of b lies in the range from 0 to 20, the value of a is either 0 or 1, and the value of m is from 3 to 8.

More preferably  $R_2$ ,  $R_3$  and  $R_4$  are independently selected from a  $C_1$ - $C_4$  alkyl group and a  $C_1$ - $C_4$  hydroxyalkyl group. In one preferred aspect at least one, preferably only one, of  $R_2$ ,  $R_3$  and  $R_4$  is a hydroxyalkyl group. The hydroxyalkyl preferably has from 1 to 4 carbon atoms, more preferably 2 or 3 carbon atoms, most preferably 2 carbon atoms. In another preferred aspect at least one of  $R_2$ ,  $R_3$  and  $R_4$  is a  $C_2$ - $C_3$  alkyl group, more preferably two  $C_2$ - $C_3$  alkyl groups are present.

Highly preferred water dispersible cationic ester surfactants are the esters having the formula:

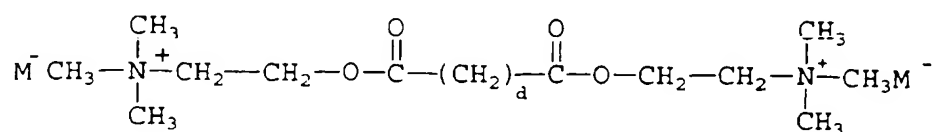
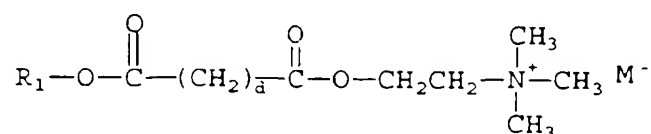


where m is from 1 to 4, preferably 2 or 3 and wherein  $R_1$  is a  $C_{11}$ - $C_{19}$  linear or branched alkyl chain.

Particularly preferred choline esters of this type include the stearyl choline ester quaternary methylammonium halides ( $R^1=C_{17}$  alkyl), palmitoyl choline ester quaternary methylammonium halides ( $R^1=C_{15}$  alkyl), myristoyl choline ester quaternary methylammonium halides ( $R^1=C_{13}$

alkyl), tallowyl choline ester quaternary methylammonium halides ( $R^1 = C_{15}-C_{17}$  alkyl), and any mixtures thereof.

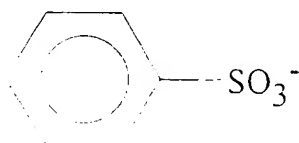
Other suitable cationic ester surfactants have the structural formulas below, wherein d may be from 0 to 20.



In a preferred aspect the cationic ester surfactant is hydrolysable under the conditions of a laundry wash method.

#### Hard Base Polymeric Component

The hard base polymeric component preferably comprises a polymer having a pendant group (that is to say a group which is not a polymeric linkage group, so that it does not form part of the polymer backbone) which is a harder base than a benzene sulphonate group



in accordance with Pearson's classification of hard and soft behaviour. Preferably the polymeric component comprises a polymer having a pendant group which is a harder base than a sulphonate group such as  $CH_3CH_2CH_2-SO_3^-$ . The polymeric component is generally formed from

The polymeric component preferably has a molecular weight of from 1500



to 150000 most preferably from 2000 to 100000, especially 5000 to 80000. Molecular weight measurements are obtained by GPC using styrene as a standard.

Particularly preferred pendant groups are carboxylic groups (references herein to acid groups also include their salts). Acrylic and maleic homopolymers or copolymers are particularly preferred.

The hard base polymer may be any organic polymeric material having a hard base group commonly used as dispersants, and anti-redeposition and soil suspension agents in detergent compositions.

Examples of organic polymeric compounds include the water soluble organic homo- or co-polymeric polycarboxylic acids or their salts in which the polycarboxylic acid comprises at least two carboxyl radicals separated from each other by not more than two carbon atoms. Polymers of the latter type are disclosed in GB-A-1,596,756. Examples of such salts are polyacrylates of MWt 1500-5000 and their copolymers with maleic anhydride, such copolymers having a molecular weight of from 2,000 to 100,000, especially 5,000 to 80,000, or even 10,000 to 50,000.

The polyamino compounds are useful herein including those derived from aspartic acid such as those disclosed in EP-A-305282, EP-A-305283 and EP-A-351629.

Terpolymers containing monomer units selected from maleic acid, acrylic acid, polyaspartic acid and vinyl alcohol, particularly those having an average molecular weight of from 5,000 to 10,000, are also suitable herein.

The hard base polymeric component is preferably present as components of any particulate components where they may be beneficial as a binder.

Detergent compositions of the present invention preferably comprise no greater than 25% sodium sulphate.

### Additional detergent components

The detergent compositions of the invention may also contain additional detergent components. The precise nature of these additional components, and levels of incorporation thereof will depend on the physical form of the composition, and the precise nature of the washing operation for which it is to be used.

The compositions of the invention preferably contain one or more additional detergent components selected from additional surfactants, additional bleaches, bleach catalysts, alkalinity systems, builders, organic polymeric compounds, additional enzymes, suds suppressors, lime soap dispersants, soil suspension and anti-redeposition agents and corrosion inhibitors.

### Peroxyacid bleaching system

A preferred feature of detergent compositions according to the invention is an organic bleaching system. Preferably the bleaching system comprises a hydrogen peroxide source and a organic peroxyacid bleach precursor compound. The production of the organic peroxyacid occurs by an in situ reaction of the precursor with a source of hydrogen peroxide. Preferred sources of hydrogen peroxide include inorganic perhydrate bleaches. In an alternative preferred execution the organic peroxyacid bleaching system comprises a preformed organic peroxyacid, which is incorporated directly into the composition. Compositions containing mixtures of a hydrogen peroxide source and organic peroxyacid precursor in combination with a preformed organic peroxyacid are also envisaged.

### Inorganic perhydrate bleaches

Inorganic perhydrate salts are a preferred source of hydrogen peroxide. These salts are normally incorporated in the form of the alkali metal

by weight. The compositions

Examples of inorganic perhydrate salts include perborate, percarbonate, perphosphate, persulfate and persilicate salts. The inorganic perhydrate salts are normally the alkali metal salts. The inorganic perhydrate salt may be included as the crystalline solid without additional protection. For certain perhydrate salts however, the preferred executions of such granular compositions utilize a coated form of the material which provides better storage stability for the perhydrate salt in the granular product. Suitable coatings comprise inorganic salts such as alkali metal silicate, carbonate or borate salts or mixtures thereof, or organic materials such as waxes, oils, or fatty soaps.

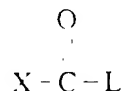
Sodium perborate is a preferred perhydrate salt and can be in the form of the monohydrate of nominal formula  $\text{NaBO}_2\text{H}_2\text{O}_2$  or the tetrahydrate  $\text{NaBO}_2\text{H}_2\text{O}_2 \cdot 3\text{H}_2\text{O}$ .

Alkali metal percarbonates, particularly sodium percarbonate are preferred perhydrates herein. Sodium percarbonate is an addition compound having a formula corresponding to  $2\text{Na}_2\text{CO}_3 \cdot 3\text{H}_2\text{O}_2$ , and is available commercially as a crystalline solid.

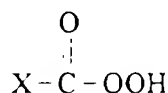
Potassium peroxymonopersulfate is another inorganic perhydrate salt of use in the detergent compositions herein.

#### Peroxyacid bleach precursor

Peroxyacid bleach precursors are compounds which react with hydrogen peroxide in a perhydrolysis reaction to produce a peroxyacid. Generally peroxyacid bleach precursors may be represented as



where L is a leaving group and X is essentially any functionality such that



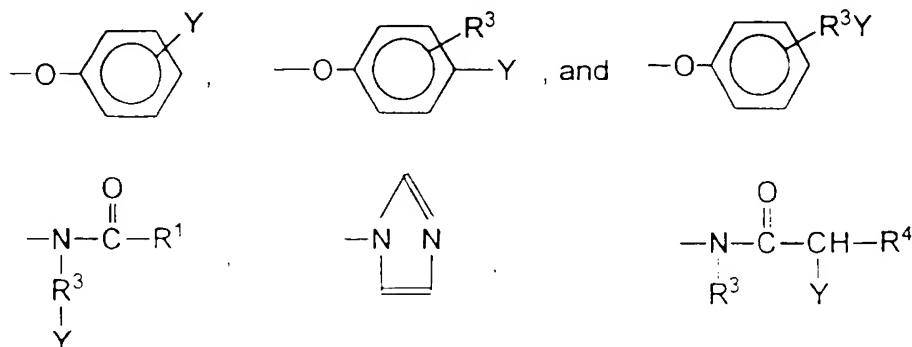
The peroxyacid bleach precursor compounds are preferably incorporated at a level of from 0.05% to 20% by weight, more preferably from 0.1% to 15% by weight, most preferably from 0.2% to 10% by weight of the detergent compositions.

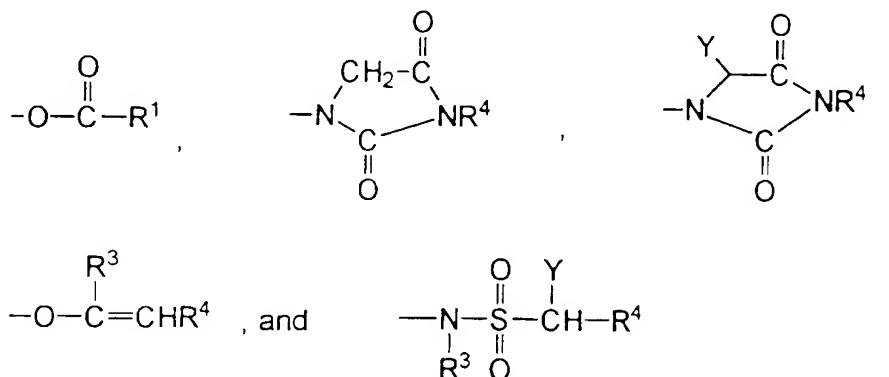
Suitable peroxyacid bleach precursor compounds typically contain one or more N- or O-acyl groups, which precursors can be selected from a wide range of classes. Suitable classes include anhydrides, esters, imides, lactams and acylated derivatives of imidazoles and oximes. Examples of useful materials within these classes are disclosed in GB-A-1586789. Suitable esters are disclosed in GB-A-836988, 864798, 1147871, 2143231 and EP-A-0170386.

#### Leaving groups

The leaving group, hereinafter L group, must be sufficiently reactive for the perhydrolysis reaction to occur within the optimum time frame (e.g., a wash cycle). However, if L is too reactive, this activator will be difficult to stabilize for use in a bleaching composition.

Preferred L groups are selected from the group consisting of:





and mixtures thereof, wherein  $\text{R}^1$  is an alkyl, aryl, or alkaryl group containing from 1 to 14 carbon atoms,  $\text{R}^3$  is an alkyl chain containing from 1 to 8 carbon atoms,  $\text{R}^4$  is H or  $\text{R}^3$ , and Y is H or a solubilizing group. Any of  $\text{R}^1$ ,  $\text{R}^3$  and  $\text{R}^4$  may be substituted by essentially any functional group including, for example alkyl, hydroxy, alkoxy, halogen, amine, nitrosyl, amide and ammonium or alkyl ammonium groups

The preferred solubilizing groups are  $-\text{SO}_3^-\text{M}^+$ ,  $-\text{CO}_2^-\text{M}^+$ ,  $-\text{SO}_4^-\text{M}^+$ ,  $-\text{N}^+(\text{R}^3)_4\text{X}^-$  and  $\text{O}=\text{N}(\text{R}^3)_3$  and most preferably  $-\text{SO}_3^-\text{M}^+$  and  $-\text{CO}_2^-\text{M}^+$  wherein  $\text{R}^3$  is an alkyl chain containing from 1 to 4 carbon atoms, M is a cation which provides solubility to the bleach activator and X is an anion which provides solubility to the bleach activator. Preferably, M is an alkali metal, ammonium or substituted ammonium cation, with sodium and potassium being most preferred, and X is a halide, hydroxide, methylsulfate or acetate anion.

#### Alkyl percarboxylic acid bleach precursors

Alkyl percarboxylic acid bleach precursors from percarboxylic acids on perhydrolysis. Preferred precursors of this type provide peracetic acid on perhydrolysis.

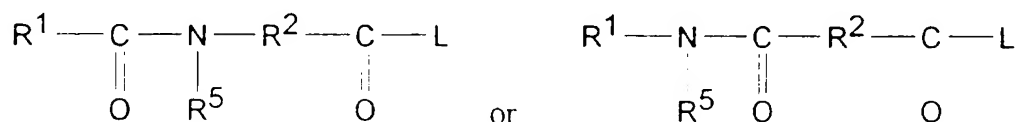
Preferred alkyl percarboxylic precursor compounds of the imide type

compounds in which the alkylene group contains 1, 2 and 6 carbon atoms. Tetraacetyl ethylene diamine (TAED) is particularly preferred.

Other preferred alkyl percarboxylic acid precursors include sodium 3,5,5-tri-methyl hexanoyloxybenzene sulfonate (iso-NOBS), sodium nonanoyloxybenzene sulfonate (NOBS), sodium acetoxybenzene sulfonate (ABS) and pentaacetyl glucose. When the bleach precursor hydrophilic, more particularly when it comprises TAED, preferably it is present in amounts of at least 1.5%, or even at least 3.5% by weight, most preferably at least 5% by weight or greater of the total detergent composition.

#### Amide substituted alkyl peroxyacid precursors

Preferred peroxyacid precursors are amide substituted alkyl peroxyacid precursor compounds, including those of the following general formulae:



wherein  $\text{R}^1$  is an aryl or alkaryl group with from about 1 to about 14 carbon atoms,  $\text{R}^2$  is an alkylene, arylene, and alkarylene group containing from about 1 to 14 carbon atoms, and  $\text{R}^5$  is H or an alkyl, aryl, or alkaryl group containing 1 to 10 carbon atoms and L can be essentially any leaving group.  $\text{R}^1$  preferably contains from about 6 to 12 carbon atoms.  $\text{R}^2$  preferably contains from about 4 to 8 carbon atoms.  $\text{R}^1$  may be straight chain or branched alkyl, substituted aryl or alkaryl containing branching, substitution, or both and may be sourced from either synthetic sources or natural sources including for example, tallow fat. Analogous structural variations are permissible for  $\text{R}^2$ .  $\text{R}^2$  can include alkyl, aryl, wherein said  $\text{R}^2$  may also contain halogen, nitrogen, sulphur and other typical substituent groups or organic compounds.  $\text{R}^5$  is preferably H or methyl.  $\text{R}^1$  and  $\text{R}^5$  should not contain more than 18 carbon atoms total. Amide substituted bleach activator compounds of this type are described in EP-A-

Preferred examples of bleach precursors of this type include amide substituted peroxyacid precursor compounds selected from (6-octanamido-caproyl)oxybenzenesulfonate, (6-decanamido-caproyl) oxybenzene-sulfonate, and the highly preferred (6-nonanamidocaproyl)oxy benzene sulfonate, and mixtures thereof as described in EP-A-0170386.

#### Perbenzoic acid precursor

Perbenzoic acid precursor compounds provide perbenzoic acid on perhydrolysis. Suitable O-acylated perbenzoic acid precursor compounds include the substituted and unsubstituted benzoyl oxybenzene sulfonates, and the benzoylation products of sorbitol, glucose, and all saccharides with benzoylating agents, and those of the imide type including N-benzoyl succinimide, tetrabenzoyl ethylene diamine and the N-benzoyl substituted ureas. Suitable imidazole type perbenzoic acid precursors include N-benzoyl imidazole and N-benzoyl benzimidazole. Other useful N-acyl group-containing perbenzoic acid precursors include N-benzoyl pyrrolidone, dibenzoyl taurine and benzoyl pyroglutamic acid.

#### Cationic peroxyacid precursors

Cationic peroxyacid precursor compounds produce cationic peroxyacids on perhydrolysis.

Typically, cationic peroxyacid precursors are formed by substituting the peroxyacid part of a suitable peroxyacid precursor compound with a positively charged functional group, such as an ammonium or alkyl ammonium group, preferably an ethyl or methyl ammonium group. Cationic peroxyacid precursors are typically present in the solid detergent compositions as a salt with a suitable anion, such as a halide ion.

The peroxyacid precursor compound to be so cationically substituted may be a perbenzoic acid, or substituted derivative thereof, precursor compound as described hereinbefore. Alternatively, the peroxyacid precursor

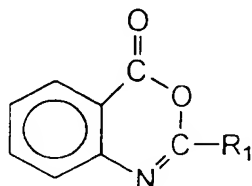
Cationic peroxyacid precursors are described in U.S. Patents 4,904,406; 4,751,015; 4,988,451; 4,397,757; 5,269,962; 5,127,852; 5,093,022; 5,106,528; U.K. 1,382,594; EP 475,512; 458,396 and 284,292; and in JP 87-318,332.

Examples of preferred cationic peroxyacid precursors are described in Patent Application No. 9407944.9 and US Patent Application Nos. 08/298903, 08/298650, 08/298904 and 08/298906.

Suitable cationic peroxyacid precursors include any of the ammonium or alkyl ammonium substituted alkyl or benzoyl oxybenzene sulfonates, N-acylated caprolactams, and monobenzoyltetraacetyl glucose benzoyl peroxides. Preferred cationic peroxyacid precursors of the N-acylated caprolactam class include the trialkyl ammonium methylene benzoyl caprolactams and the trialkyl ammonium methylene alkyl caprolactams.

#### Benzoxazin organic peroxyacid precursors

Also suitable are precursor compounds of the benzoxazin-type, as disclosed for example in EP-A-332,294 and EP-A-482,807, particularly those having the formula:



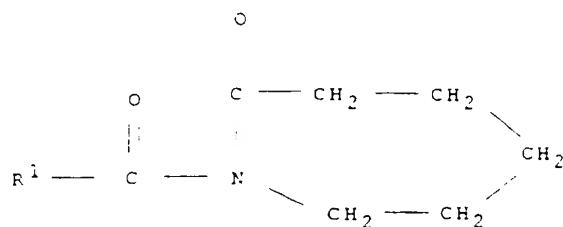
wherein  $R_1$  is an alkyl, alkaryl, aryl, or arylalkyl.

#### N-acylated lactam precursors

Still another class of hydrophobic bleach activators are the N-acylated precursor compounds of the lactam class disclosed generally in GB-A-

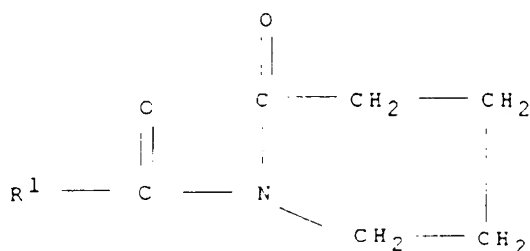


Suitable caprolactam bleach precursors are of the formula:



wherein  $R^1$  is an alkyl, aryl, alkoxyaryl or alkaryl group containing from 6 to 12 carbon atoms. Preferred hydrophobic N-acyl caprolactam bleach precursor materials are selected from benzoyl caprolactam, octanoyl caprolactam, nonanoyl caprolactam, decanoyl caprolactam, undecenoyl caprolactam, 3,5,5-trimethylhexanoyl caprolactam and mixtures thereof. A most preferred is nonanoyl caprolactam.

Suitable valero lactams have the formula:



wherein  $R^1$  is an alkyl, aryl, alkoxyaryl or alkaryl group containing from 6 to 12 carbon atoms. More preferably,  $R^1$  is selected from phenyl, heptyl, octyl, nonyl, 2,4,4-trimethylpentyl, decenyl and mixtures thereof.

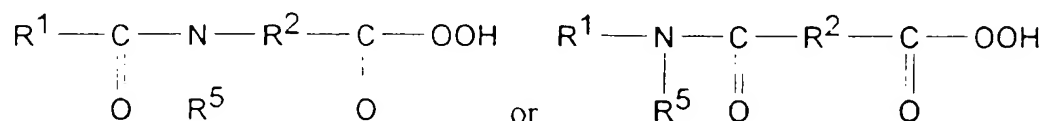
Mixtures of any of the peroxyacid bleach precursor, herein before described, may also be used.

#### Preformed organic peroxyacid

The organic peroxyacid bleaching system may contain, in addition to, or as an alternative to, the peroxyacid precursor, a suitable catalyst.

0.05% to 20% by weight, more preferably from 1% to 10% by weight of the composition.

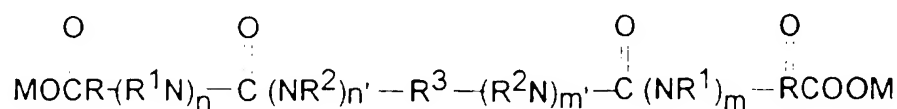
A preferred class of hydrophobic organic peroxyacid compounds are the amide substituted compounds of the following general formulae:



wherein  $\text{R}^1$  is an aryl or alkaryl group with from about 1 to about 14 carbon atoms,  $\text{R}^2$  is an alkylene, arylene, and alkarylene group containing from about 1 to 14 carbon atoms, and  $\text{R}^5$  is H or an alkyl, aryl, or alkaryl group containing 1 to 10 carbon atoms.  $\text{R}^1$  preferably contains from about 6 to 12 carbon atoms.  $\text{R}^2$  preferably contains from about 4 to 8 carbon atoms.  $\text{R}^1$  may be straight chain or branched alkyl, substituted aryl or alkaryl containing branching, substitution, or both and may be sourced from either synthetic sources or natural sources including for example, tallow fat. Analogous structural variations are permissible for  $\text{R}^2$ .  $\text{R}^2$  can include alkyl, aryl, wherein said  $\text{R}^2$  may also contain halogen, nitrogen, sulphur and other typical substituent groups or organic compounds.  $\text{R}^5$  is preferably H or methyl.  $\text{R}^1$  and  $\text{R}^5$  should not contain more than 18 carbon atoms total. Amide substituted bleach activator compounds of this type are described in EP-A-0170386. Suitable examples of this class of agents include (6-octylamino)-6-oxo-caproic acid, (6-nonylamino)-6-oxo-caproic acid, (6-decylamino)-6-oxo-caproic acid, magnesium monoperoxyphthalate hexahydrate, the magnesium salt of metachloro perbenzoic acid, 4-nonylamino-4-oxoperoxybutyric acid and diperoxidodecanedioic acid. Such bleaching agents are disclosed in U.S. 4,483,781, U.S. 4,634,551, EP 0,133,354, U.S. 4,412,934 and EP 0,170,386. A preferred hydrophobic preformed peroxyacid bleach compound for the purpose of the invention is monononylamido peroxycarboxylic acid.

Other suitable organic peroxyacids include diperoxyalkanedioic acids, such

Other suitable organic peroxyacids include diamino peroxyacids, which are disclosed in WO 95/ 03275, with the following general formula:



wherein:

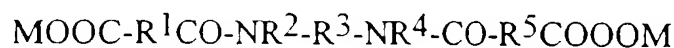
R is selected from the group consisting of C<sub>1</sub>-C<sub>12</sub> alkylene, C<sub>5</sub>-C<sub>12</sub> cycloalkylene, C<sub>6</sub>-C<sub>12</sub> arylene and radical combinations thereof;  
 R<sup>1</sup> and R<sup>2</sup> are independently selected from the group consisting of H, C<sub>1</sub>-C<sub>16</sub> alkyl and C<sub>6</sub>-C<sub>12</sub> aryl radicals and a radical that can form a C<sub>3</sub>-C<sub>12</sub> ring together with R<sup>3</sup> and both nitrogens; R<sup>3</sup> is selected from the group consisting of C<sub>1</sub>-C<sub>12</sub> alkylene, C<sub>5</sub>-C<sub>12</sub> cycloalkylene and C<sub>6</sub>-C<sub>12</sub> arylene radicals; n and n' each are an integer chosen such that the sum thereof is 1; m and m' each are an integer chosen such that the sum thereof is 1; and M is selected from the group consisting of H, alkali metal, alkaline earth metal, ammonium, alkanolammonium cations and radicals and combinations thereof.

Other suitable organic peroxyacids are include the amido peroxyacids which are disclosed in WO 95/ 16673, with the following general structure:



in which X represents hydrogen or a compatible substituent, Ar is an aryl group, R represents (CH<sub>2</sub>)<sub>n</sub> in which n = 2 or 3, and Y and Z each represent independently a substituent selected from hydrogen or an alkyl or aryl or alkaryl group or an aryl group substituted by a compatible substituent provided that at least one of Y and Z is not hydrogen if n = 3. The substituent X on the benzene nucleus is preferably a hydrogen or a meta or para substituent, selected from the group comprising halogen, typically chlorine atom, or some other non-released non-interfering species such as an alkyl group, conveniently up to C<sub>6</sub> for example a methyl, ethyl or propyl group. Alternatively, X can represent a second amido-

in which R, Y, Z and n are as defined above.



wherein R<sup>1</sup> is selected from the group consisting of C<sub>1</sub>-C<sub>12</sub> alkylene, C<sub>5</sub>-C<sub>12</sub> cycloalkylene, C<sub>6</sub>-C<sub>12</sub> arylene and radical combinations thereof; R

#### Additional surfactant

The detergent compositions of the invention preferably contain an additional surfactant preferably selected from anionic, nonionic, ampholytic, amphoteric and zwitterionic surfactants and mixtures thereof.

A typical listing of anionic, nonionic, ampholytic, and zwitterionic classes, and species of these surfactants, is given in U.S.P. 3,929,678 issued to Laughlin and Heuring on December 30, 1975. Further examples are given in "Surface Active Agents and Detergents" (Vol. I and II by Schwartz, Perry and Berch).

Where present, ampholytic, amphoteric and zwitterionic surfactants are generally used in combination with one or more anionic and/or nonionic surfactants.

#### Anionic surfactant

The detergent compositions of the present invention preferably comprise an additional anionic surfactant. Essentially any anionic surfactants useful for detergative purposes can be comprised in the detergent composition. These can include salts (including, for example, sodium, potassium, ammonium, and substituted ammonium salts such as mono-, di- and triethanolamine salts) of the anionic sulfate, sulfonate, carboxylate and sarcosinate surfactants. Anionic sulfate surfactants are preferred.

succinates and sulfosuccinates, monoesters of sulfosuccinate (especially

saturated and unsaturated C<sub>12</sub>-C<sub>18</sub> monoesters) diesters of sulfosuccinate (especially saturated and unsaturated C<sub>6</sub>-C<sub>14</sub> diesters), N-acyl sarcosinates. Resin acids and hydrogenated resin acids are also suitable, such as rosin, hydrogenated rosin, and resin acids and hydrogenated resin acids present in or derived from tallow oil.

#### Anionic sulfate surfactant

Anionic sulfate surfactants suitable for use herein include the linear and branched primary and secondary alkyl sulfates, alkyl ethoxysulfates, fatty oleoyl glycerol sulfates, alkyl phenol ethylene oxide ether sulfates, the C<sub>5</sub>-C<sub>17</sub> acyl-N-(C<sub>1</sub>-C<sub>4</sub> alkyl) and -N-(C<sub>1</sub>-C<sub>2</sub> hydroxyalkyl) glucamine sulfates, and sulfates of alkylpolysaccharides such as the sulfates of alkylpolyglucoside (the nonionic nonsulfated compounds being described herein).

Alkyl sulfate surfactants are preferably selected from the linear and branched primary C<sub>10</sub>-C<sub>18</sub> alkyl sulfates, more preferably the C<sub>11</sub>-C<sub>15</sub> branched chain alkyl sulfates and the C<sub>12</sub>-C<sub>14</sub> linear chain alkyl sulfates.

Alkyl ethoxysulfate surfactants are preferably selected from the group consisting of the C<sub>10</sub>-C<sub>18</sub> alkyl sulfates which have been ethoxylated with from 0.5 to 20 moles of ethylene oxide per molecule. More preferably, the alkyl ethoxysulfate surfactant is a C<sub>11</sub>-C<sub>18</sub>, most preferably C<sub>11</sub>-C<sub>15</sub> alkyl sulfate which has been ethoxylated with from 0.5 to 7, preferably from 1 to 5, moles of ethylene oxide per molecule.

A particularly preferred aspect of the invention employs mixtures of the preferred alkyl sulfate and alkyl ethoxysulfate surfactants. Such mixtures have been disclosed in PCT Patent Application No. WO 93/18124. When C<sub>12</sub> alkyl benzene sulfonate is incorporated into the detergent compositions of the invention, it may be present in an amount below 8% by weight of the composition.

### Anionic sulfonate surfactant

Anionic sulfonate surfactants suitable for use herein include the salts of C<sub>5</sub>-C<sub>20</sub> linear alkylbenzene sulfonates, alkyl ester sulfonates, C<sub>6</sub>-C<sub>22</sub> primary or secondary alkane sulfonates, C<sub>6</sub>-C<sub>24</sub> olefin sulfonates, sulfonated polycarboxylic acids, alkyl glycerol sulfonates, fatty acyl glycerol sulfonates, fatty oleyl glycerol sulfonates, and any mixtures thereof. When C<sub>12</sub> alkyl benzene sulfonate is incorporated into the detergent compositions of the invention, it may be present in an amount below 8% by weight of the composition.

### Anionic carboxylate surfactant

Suitable anionic carboxylate surfactants include the alkyl ethoxy carboxylates, the alkyl polyethoxy polycarboxylate surfactants and the soaps ('alkyl carboxyls'), especially certain secondary soaps as described herein.

Suitable alkyl ethoxy carboxylates include those with the formula  $RO(CH_2CH_2O)_xCH_2COO^-M^+$  wherein R is a C<sub>6</sub> to C<sub>18</sub> alkyl group, x ranges from 0 to 10, and the ethoxylate distribution is such that, on a weight basis, the amount of material where x is 0 is less than 20 % and M is a cation. Suitable alkyl polyethoxy polycarboxylate surfactants include those having the formula  $RO-(CHR_1-CHR_2-O)-R_3$  wherein R is a C<sub>6</sub> to C<sub>18</sub> alkyl group, x is from 1 to 25, R<sub>1</sub> and R<sub>2</sub> are selected from the group consisting of hydrogen, methyl acid radical, succinic acid radical, hydroxysuccinic acid radical, and mixtures thereof, and R<sub>3</sub> is selected from the group consisting of hydrogen, substituted or unsubstituted hydrocarbon having between 1 and 8 carbon atoms, and mixtures thereof.

Suitable soap surfactants include the secondary soap surfactants which contain a carboxyl unit connected to a secondary carbon. Preferred secondary soap surfactants for use herein are water-soluble members selected from the group consisting of the water-soluble salts of 2-methyl-1-

also be included as suds suppressors.

### Alkali metal sarcosinate surfactant

Other suitable anionic surfactants are the alkali metal sarcosinates of formula  $R-CON(R^1)CH_2COOM$ , wherein R is a C<sub>5</sub>-C<sub>17</sub> linear or branched alkyl or alkenyl group, R<sup>1</sup> is a C<sub>1</sub>-C<sub>4</sub> alkyl group and M is an alkali metal ion. Preferred examples are the myristyl and oleoyl methyl sarcosinates in the form of their sodium salts.

### Alkoxyated nonionic surfactant

Essentially any alkoxyated nonionic surfactants are suitable herein. The ethoxyated and propoxyated nonionic surfactants are preferred.

Preferred alkoxyated surfactants can be selected from the classes of the nonionic condensates of alkyl phenols, nonionic ethoxyated alcohols, nonionic ethoxyated/propoxyated fatty alcohols, nonionic ethoxylate/propoxylate condensates with propylene glycol, and the nonionic ethoxylate condensation products with propylene oxide/ethylene diamine adducts.

### Nonionic alkoxyated alcohol surfactant

The condensation products of aliphatic alcohols with from 1 to 25 moles of alkylene oxide, particularly ethylene oxide and/or propylene oxide, are suitable for use herein. The alkyl chain of the aliphatic alcohol can either be straight or branched, primary or secondary, and generally contains from 6 to 22 carbon atoms. Particularly preferred are the condensation products of alcohols having an alkyl group containing from 8 to 20 carbon atoms with from 2 to 10 moles of ethylene oxide per mole of alcohol.

### Nonionic polyhydroxy fatty acid amide surfactant

Polyhydroxy fatty acid amides suitable for use herein are those having the

preferable C<sub>1</sub>-C<sub>4</sub> alkyl, more preferably C<sub>1</sub> or C<sub>2</sub> alkyl, most preferably

C<sub>1</sub> alkyl (i.e., methyl); and R<sub>2</sub> is a C<sub>5</sub>-C<sub>31</sub> hydrocarbyl, preferably straight-chain C<sub>5</sub>-C<sub>19</sub> alkyl or alkenyl, more preferably straight-chain C<sub>9</sub>-C<sub>17</sub> alkyl or alkenyl, most preferably straight-chain C<sub>11</sub>-C<sub>17</sub> alkyl or alkenyl, or mixture thereof; and Z is a polyhydroxyhydrocarbyl having a linear hydrocarbyl chain with at least 3 hydroxyls directly connected to the chain, or an alkoxylated derivative (preferably ethoxylated or propoxylated) thereof. Z preferably will be derived from a reducing sugar in a reductive amination reaction; more preferably Z is a glycityl.

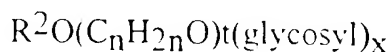
#### Nonionic fatty acid amide surfactant

Suitable fatty acid amide surfactants include those having the formula: R<sup>6</sup>CON(R<sup>7</sup>)<sub>2</sub> wherein R<sup>6</sup> is an alkyl group containing from 7 to 21, preferably from 9 to 17 carbon atoms and each R<sup>7</sup> is selected from the group consisting of hydrogen, C<sub>1</sub>-C<sub>4</sub> alkyl, C<sub>1</sub>-C<sub>4</sub> hydroxyalkyl, and -(C<sub>2</sub>H<sub>4</sub>O)<sub>x</sub>H, where x is in the range of from 1 to 3.

#### Nonionic alkylpolysaccharide surfactant

Suitable alkylpolysaccharides for use herein are disclosed in U.S. Patent 4,565,647, Llenado, issued January 21, 1986, having a hydrophobic group containing from 6 to 30 carbon atoms and a polysaccharide, e.g., a polyglycoside, hydrophilic group containing from 1.3 to 10 saccharide units.

Preferred alkylpolyglycosides have the formula



wherein R<sup>2</sup> is selected from the group consisting of alkyl, alkylphenyl, hydroxyalkyl, hydroxyalkylphenyl, and mixtures thereof in which the alkyl groups contain from 10 to 18 carbon atoms; n is 2 or 3; t is from 0 to 10, and x is from 1.3 to 8. The glycosyl is preferably derived from glucose.



### Amphoteric surfactant

Suitable amphoteric surfactants for use herein include the amine oxide surfactants and the alkyl amphocarboxylic acids.

Suitable amine oxides include those compounds having the formula  $R^3(OR^4)_xN^0(R^5)_2$  wherein  $R^3$  is selected from an alkyl, hydroxyalkyl, acylamidopropoyl and alkyl phenyl group, or mixtures thereof, containing from 8 to 26 carbon atoms;  $R^4$  is an alkylene or hydroxyalkylene group containing from 2 to 3 carbon atoms, or mixtures thereof;  $x$  is from 0 to 5, preferably from 0 to 3; and each  $R^5$  is an alkyl or hydroxyalkyl group containing from 1 to 3, or a polyethylene oxide group containing from 1 to 3 ethylene oxide groups. Preferred are  $C_{10}$ - $C_{18}$  alkyl dimethylamine oxide, and  $C_{10}$ - $C_{18}$  acylamido alkyl dimethylamine oxide.

A suitable example of an alkyl aphodicarboxylic acid is Miranol(TM) C2M Conc. manufactured by Miranol, Inc., Dayton, NJ.

### Zwitterionic surfactant

Zwitterionic surfactants can also be incorporated into the detergent compositions hereof. These surfactants can be broadly described as derivatives of secondary and tertiary amines, derivatives of heterocyclic secondary and tertiary amines, or derivatives of quaternary ammonium, quaternary phosphonium or tertiary sulfonium compounds. Betaine and sultaine surfactants are exemplary zwitterionic surfactants for use herein.

Suitable betaines are those compounds having the formula  $R(R')_2N^+R^2COO^-$  wherein  $R$  is a  $C_6$ - $C_{18}$  hydrocarbyl group, each  $R^1$  is typically  $C_1$ - $C_3$  alkyl, and  $R^2$  is a  $C_1$ - $C_5$  hydrocarbyl group. Preferred betaines are  $C_{12}$ - $C_{18}$  dimethyl-ammonio hexanoate and the  $C_{10}$ - $C_{18}$  acylamidopropane (or ethane) dimethyl (or diethyl) betaines. Complex betaine surfactants are also suitable for use herein.

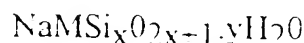
### Alkalinity

In the detergent compositions of the present invention preferably a alkalinity system is present to achieve optimal cationic ester surfactant performance. The alkalinity system comprises components capable of providing alkalinity species in solution. By alkalinity species it is meant herein: carbonate, bicarbonate, hydroxide, the various silicate anions, percarbonate, perborates, perphosphates, persulfate and persilicate. Such alkalinity species can be formed for example, when alkaline salts selected from alkali metal or alkaline earth carbonate, bicarbonate, hydroxide or silicate, including crystalline layered silicate, salts and percarbonate, perborates, perphosphates, persulfate and persilicate salts and any mixtures thereof are dissolved in water.

Examples of carbonates are the alkaline earth and alkali metal carbonates, including sodium carbonate and sesqui-carbonate and any mixtures thereof with ultra-fine calcium carbonate such as are disclosed in German Patent Application No. 2,321,001 published on November 15, 1973.

Suitable silicates include the water soluble sodium silicates with an  $\text{SiO}_2$ :  $\text{Na}_2\text{O}$  ratio of from 1.0 to 2.8, with ratios of from 1.6 to 2.0 being preferred, and 2.0 ratio being most preferred. The silicates may be in the form of either the anhydrous salt or a hydrated salt. Sodium silicate with an  $\text{SiO}_2$ :  $\text{Na}_2\text{O}$  ratio of 2.0 is the most preferred silicate.

Preferred crystalline layered silicates for use herein have the general formula



wherein M is sodium or hydrogen, x is a number from 1.9 to 4 and y is a number from 0 to 20. Crystalline layered sodium silicates of this type are disclosed in EP-A-0164514 and methods for their preparation are disclosed in DE-A-3417649 and DE-A-3742043. Herein x in the general formula

### Water-soluble builder compound

The detergent compositions of the present invention preferably contain a water-soluble builder compound, typically present at a level of from 1% to 80% by weight, preferably from 10% to 70% by weight, most preferably from 20% to 60% by weight of the composition.

Suitable water-soluble builder compounds include the water soluble monomeric polycarboxylates, or their acid forms, homo or copolymeric polycarboxylic acids or their salts in which the polycarboxylic acid comprises at least two carboxylic radicals separated from each other by not more than two carbon atoms, borates, phosphates, and mixtures of any of the foregoing.

The carboxylate or polycarboxylate builder can be monomeric or oligomeric in type although monomeric polycarboxylates are generally preferred for reasons of cost and performance.

Suitable carboxylates containing one carboxy group include the water soluble salts of lactic acid, glycolic acid and ether derivatives thereof. Polycarboxylates containing two carboxy groups include the water-soluble salts of succinic acid, malonic acid, (ethylenedioxy) diacetic acid, maleic acid, diglycolic acid, tartaric acid, tartronic acid and fumaric acid, as well as the ether carboxylates and the sulfinyl carboxylates. Polycarboxylates containing three carboxy groups include, in particular, water-soluble citrates, aconitrates and citraconates as well as succinate derivatives such as the carboxymethyloxysuccinates described in British Patent No. 1,379,241, lactoxysuccinates described in British Patent No. 1,389,732, and aminosuccinates described in Netherlands Application 7205873, and the oxypolycarboxylate materials such as 2-oxa-1,1,3-propane tricarboxylates described in British Patent No. 1,387,447.

Polycarboxylates containing four carboxy groups include oxydisuccinates disclosed in British Patent No. 1,261,829, 1,1,2,2-ethane tetracarboxylates,

derivatives disclosed in British Patent Nos. 1,398,421 and 1,398,422 and 1,1,2,2-

U.S. Patent No. 3,936,448, and the sulfonated pyrolysed citrates described in British Patent No. 1,439,000. Preferred polycarboxylates are hydroxycarboxylates containing up to three carboxy groups per molecule, more particularly citrates.

The parent acids of monomeric or oligomeric polycarboxylate chelating agents or mixtures thereof with their salts, e.g. citric acid or citrate/citric acid mixtures are also contemplated as useful builder components.

Borate builders, as well as builders containing borate-forming materials that can produce borate under detergent storage or wash conditions are useful water-soluble builders herein.

Suitable examples of water-soluble phosphate builders are the alkali metal tripolyphosphates, sodium, potassium and ammonium pyrophosphate, sodium and potassium and ammonium pyrophosphate, sodium and potassium orthophosphate, sodium polymeta/phosphate in which the degree of polymerization ranges from about 6 to 21, and salts of phytic acid.

The compositions of the invention contain less than 20% by weight phosphate component, preferably less than 15%, or even less than 10% or 5% by weight phosphate component. Thus, if phosphate builders are present as the phosphate component, lower amounts are preferred.

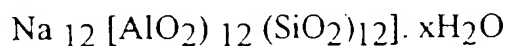
### Partially soluble or insoluble builder compound

The detergent compositions of the present invention may contain a partially soluble or insoluble builder compound, typically present at a level of from 1% to 80% by weight, preferably from 10% to 70% by weight, most preferably from 20% to 60% weight of the composition.

Examples of largely water insoluble builders include the sodium aluminosilicates.

more preferably from 10 to 264. The aluminosilicate material are in hydrated form and are preferably crystalline, containing from 10% to 28%, more preferably from 18% to 22% water in bound form.

The aluminosilicate zeolites can be naturally occurring materials, but are preferably synthetically derived. Synthetic crystalline aluminosilicate ion exchange materials are available under the designations Zeolite A, Zeolite B, Zeolite P, Zeolite X, Zeolite HS Zeolite MAP and mixtures thereof. Zeolite A has the formula



wherein x is from 20 to 30, especially 27. Zeolite X has the formula  $\text{Na}_{86} [(\text{AlO}_2)_{86}(\text{SiO}_2)_{106}] \cdot 276 \text{H}_2\text{O}$ .

#### Bleach catalyst

The compositions optionally contain a transition metal containing bleach catalyst. One suitable type of bleach catalyst is a catalyst system comprising a heavy metal cation of defined bleach catalytic activity, such as copper, iron or manganese cations, an auxiliary metal cation having little or no bleach catalytic activity, such as zinc or aluminum cations, and a sequestrant having defined stability constants for the catalytic and auxiliary metal cations, particularly ethylenediaminetetraacetic acid, ethylenediaminetetra(methylenephosphonic acid) and water-soluble salts thereof. Such catalysts are disclosed in U.S. Pat. 4,430,243.

Other types of bleach catalysts include the manganese-based complexes disclosed in U.S. Pat. 5,246,621 and U.S. Pat. 5,244,594. Preferred examples of these catalysts include  $\text{Mn}^{\text{IV}}_2(\text{u-O})_3(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2(\text{PF}_6)_2$ ,  $\text{Mn}^{\text{III}}_2(\text{u-O})_1(\text{u-OAc})_2(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2(\text{ClO}_4)_2$ ,  $\text{Mn}^{\text{IV}}_4(\text{u-O})_6(1,4,7\text{-triazacyclononane})_4(\text{ClO}_4)_2$ ,  $\text{Mn}^{\text{III}}\text{Mn}^{\text{IV}}_4(\text{u-O})_1(\text{u-OAc})_2(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2(\text{ClO}_4)_3$ , and mixtures thereof. Others are described

2-methyl-1,4,7-triazacyclononane, 2-methyl-1,4,7-triazacyclononane, 1,2,4,7-tetramethyl-1,4,7-triazacyclononane, and mixtures thereof.

For examples of suitable bleach catalysts see U.S. Pat. 4,246,612 and U.S. Pat. 5,227,084. See also U.S. Pat. 5,194,416 which teaches mononuclear manganese (IV) complexes such as  $\text{Mn}(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})(\text{OCH}_3)_3(\text{PF}_6)$ . Still another type of bleach catalyst, as disclosed in U.S. Pat. 5,114,606, is a water-soluble complex of manganese (III), and/or (IV) with a ligand which is a non-carboxylate polyhydroxy compound having at least three consecutive C-OH groups. Other examples include binuclear Mn complexed with tetra-N-dentate and bi-N-dentate ligands, including  $\text{N}_4\text{Mn}^{\text{III}}(\text{u-O})_2\text{Mn}^{\text{IV}}\text{N}_4)^+$  and  $[\text{Bipy}_2\text{Mn}^{\text{III}}(\text{u-O})_2\text{Mn}^{\text{IV}}\text{bipy}_2](\text{ClO}_4)_3$ .

Further suitable bleach catalysts are described, for example, in European patent application No. 408,131 (cobalt complex catalysts), European patent applications, publication nos. 384,503, and 306,089 (metallo-porphyrin catalysts), U.S. 4,728,455 (manganese/multidentate ligand catalyst), U.S. 4,711,748 and European patent application, publication no. 224,952, (absorbed manganese on aluminosilicate catalyst), U.S. 4,601,845 (aluminosilicate support with manganese and zinc or magnesium salt), U.S. 4,626,373 (manganese/ligand catalyst), U.S. 4,119,557 (ferric complex catalyst), German Pat. specification 2,054,019 (cobalt chelant catalyst) Canadian 866,191 (transition metal-containing salts), U.S. 4,430,243 (chelants with manganese cations and non-catalytic metal cations), and U.S. 4,728,455 (manganese gluconate catalysts).

#### Heavy metal ion sequestrant

The detergent compositions of the invention preferably contain as an optional component a heavy metal ion sequestrant. By heavy metal ion sequestrant it is meant herein components which act to sequester (chelate) heavy metal ions. These components may also have calcium and magnesium chelation capacity, but preferentially they show selectivity to

Heavy metal ion sequestrants are generally present at a level of from 0.005% to 20%, preferably from 0.1% to 10%, more preferably from 0.25% to 7.5% and most preferably from 0.5% to 5% by weight of the compositions.

Suitable heavy metal ion sequestrants for use herein include organic phosphonates, such as the amino alkylene poly (alkylene phosphonates), alkali metal ethane 1-hydroxy disphosphonates and nitrilo trimethylene phosphonates.

Preferred among the above species are diethylene triamine penta (methylene phosphonate), ethylene diamine tri (methylene phosphonate) hexamethylene diamine tetra (methylene phosphonate) and hydroxy-ethylene 1,1 diphosphonate.

Other suitable heavy metal ion sequestrant for use herein include nitrilotriacetic acid and polyaminocarboxylic acids such as ethylenediaminetetracetic acid, ethylenetriamine pentacetic acid, ethylenediamine disuccinic acid, ethylenediamine diglutamic acid, 2-hydroxypropylenediamine disuccinic acid or any salts thereof. Especially preferred is ethylenediamine-N,N'-disuccinic acid (EDDS) or the alkali metal, alkaline earth metal, ammonium, or substituted ammonium salts thereof, or mixtures thereof.

Other suitable heavy metal ion sequestrants for use herein are iminodiacetic acid derivatives such as 2-hydroxyethyl diacetic acid or glyceryl imino diacetic acid, described in EP-A-317,542 and EP-A-399,133. The iminodiacetic acid-N-2-hydroxypropyl sulfonic acid and aspartic acid N-carboxymethyl N-2-hydroxypropyl-3-sulfonic acid sequestrants described in EP-A-516,102 are also suitable herein. The  $\beta$ -alanine-N,N'-diacetic acid, aspartic acid-N,N'-diacetic acid, aspartic acid-N-monoacetic acid and iminodisuccinic acid sequestrants described in EP-A-509,382 are also suitable.

EP-A-528,822 describes a suitable alkyl iminodiacetic acid sequestrant

Dipicolinic acid and 2-phosphonobutane-1,2,4-tricarboxylic acid are also suitable. Glycinamide-N,N'-disuccinic acid (GADS), ethylenediamine-N-N'-diglutamic acid (EDDG) and 2-hydroxypropylenediamine-N-N'-disuccinic acid (HPDDS) are also suitable.

### Enzyme

Another preferred ingredient useful in the detergent compositions is one or more additional enzymes.

Preferred additional enzymatic materials include the commercially available lipases, cutinases, amylases, neutral and alkaline proteases, cellulases, endolases, esterases, pectinases, lactases and peroxidases conventionally incorporated into detergent compositions. Suitable enzymes are discussed in US Patents 3,519,570 and 3,533,139.

Preferred commercially available protease enzymes include those sold under the tradenames Alcalase, Savinase, Primase, Durazym, and Esperase by Novo Industries A/S (Denmark), those sold under the tradename Maxatase, Maxacal and Maxapem by Gist-Brocades, those sold by Genencor International, and those sold under the tradename Opticlean and Optimase by Solvay Enzymes. Protease enzyme may be incorporated into the compositions in accordance with the invention at a level of from 0.0001% to 4% active enzyme by weight of the composition.

Preferred amylases include, for example,  $\alpha$ -amylases obtained from a special strain of *B licheniformis*, described in more detail in GB-1,269,839 (Novo). Preferred commercially available amylases include for example, those sold under the tradename Rapidase by Gist-Brocades, and those sold under the tradename Termamyl and BAN by Novo Industries A/S. Amylase enzyme may be incorporated into the composition in accordance with the invention at a level of from 0.0001% to 2% active enzyme by weight of the composition.

...preferably from 0.001% to 0.5% by weight of the compositions.



The lipase may be fungal or bacterial in origin being obtained, for example, from a lipase producing strain of Humicola sp., Thermomyces sp. or Pseudomonas sp. including Pseudomonas pseudoalcaligenes or Pseudomonas fluorescens. Lipase from chemically or genetically modified mutants of these strains are also useful herein. A preferred lipase is derived from Pseudomonas pseudoalcaligenes, which is described in Granted European Patent, EP-B-0218272.

Another preferred lipase herein is obtained by cloning the gene from Humicola lanuginosa and expressing the gene in Aspergillus oryza, as host, as described in European Patent Application, EP-A-0258 068, which is commercially available from Novo Industri A/S, Bagsvaerd, Denmark, under the trade name Lipolase. This lipase is also described in U.S. Patent 4,810,414, Høge-Jensen et al, issued March 7, 1989.

#### Organic polymeric compound

Organic polymeric compounds are preferred additional components of the detergent compositions in accord with the invention. Organic polymeric compounds suitable for incorporation in the detergent compositions herein include cellulose derivatives such as methylcellulose, carboxymethylcellulose, hydroxypropylmethylcellulose and hydroxyethylcellulose.

Further useful organic polymeric compounds are the polyethylene glycols, particularly those of molecular weight 1000-10000, more particularly 2000 to 8000 and most preferably about 4000.

#### Suds suppressing system

The detergent compositions of the invention, when formulated for use in machine washing compositions, preferably comprise a suds suppressing system present at a level of from 0.01% to 15%, preferably from 0.05% to

Suitable suds suppressing systems for use herein may comprise essentially any known antifoam compound, including, for example silicone antifoam compounds and 2-alkyl alcanol antifoam compounds.

By antifoam compound it is meant herein any compound or mixtures of compounds which act such as to depress the foaming or sudsing produced by a solution of a detergent composition, particularly in the presence of agitation of that solution.

Particularly preferred antifoam compounds for use herein are silicone antifoam compounds defined herein as any antifoam compound including a silicone component. Such silicone antifoam compounds also typically contain a silica component. The term "silicone" as used herein, and in general throughout the industry, encompasses a variety of relatively high molecular weight polymers containing siloxane units and hydrocarbyl group of various types. Preferred silicone antifoam compounds are the siloxanes, particularly the polydimethylsiloxanes having trimethylsilyl end blocking units.

Other suitable antifoam compounds include the monocarboxylic fatty acids and soluble salts thereof. These materials are described in US Patent 2,954,347, issued September 27, 1960 to Wayne St. John. The monocarboxylic fatty acids, and salts thereof, for use as suds suppressor typically have hydrocarbyl chains of 10 to 24 carbon atoms, preferably 12 to 18 carbon atoms. Suitable salts include the alkali metal salts such as sodium, potassium, and lithium salts, and ammonium and alkanolammonium salts.

Other suitable antifoam compounds include, for example, high molecular weight fatty esters (e.g. fatty acid triglycerides), fatty acid esters of monovalent alcohols, aliphatic C<sub>18</sub>-C<sub>40</sub> ketones (e.g. stearone) N-alkylated amino triazines such as tri- to hexa-alkylmelamines or di- to tetra alkyl diamine chlortriazines formed as products of cyanuric chloride with two or three moles of a primary or secondary amine containing 1 to 24

A preferred suds suppressing system comprises

- (a) antifoam compound, preferably silicone antifoam compound, most preferably a silicone antifoam compound comprising in combination
  - (i) polydimethyl siloxane, at a level of from 50% to 99%, preferably 75% to 95% by weight of the silicone antifoam compound; and
  - (ii) silica, at a level of from 1% to 50%, preferably 5% to 25% by weight of the silicone/silica antifoam compound;

wherein said silica/silicone antifoam compound is incorporated at a level of from 5% to 50%, preferably 10% to 40% by weight;

- (b) a dispersant compound, most preferably comprising a silicone glycol rake copolymer with a polyoxyalkylene content of 72-78% and an ethylene oxide to propylene oxide ratio of from 1:0.9 to 1:1.1, at a level of from 0.5% to 10%, preferably 1% to 10% by weight; a particularly preferred silicone glycol rake copolymer of this type is DCO544, commercially available from DOW Corning under the tradename DCO544;
- (c) an inert carrier fluid compound, most preferably comprising a C<sub>16</sub>-C<sub>18</sub> ethoxylated alcohol with a degree of ethoxylation of from 5 to 50, preferably 8 to 15, at a level of from 5% to 80%, preferably 10% to 70%, by weight;

A highly preferred particulate suds suppressing system is described in EP-A-0210731 and comprises a silicone antifoam compound and an organic carrier material having a melting point in the range 50°C to 85°C, wherein the organic carrier material comprises a monoester of glycerol and a fatty acid having a carbon chain containing from 12 to 20 carbon atoms. EP-A-

carbon chain containing from 12 to 20 carbon atoms, or a mixture thereof, with a melting point of from 45°C to 80°C.

#### Clay softening system

The detergent compositions may contain a clay softening system comprising a clay mineral compound and optionally a clay flocculating agent.

The clay mineral compound is preferably a smectite clay compound. Smectite clays are disclosed in the US Patents No.s 3,862,058, 3,948,790, 3,954,632 and 4,062,647. European Patents No.s EP-A-299,575 and EP-A-313,146 in the name of the Procter and Gamble Company describe suitable organic polymeric clay flocculating agents.

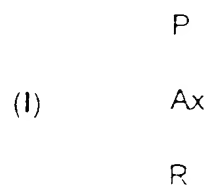
#### Polymeric dye transfer inhibiting agents

The detergent compositions herein may also comprise from 0.01% to 10 %, preferably from 0.05% to 0.5% by weight of polymeric dye transfer inhibiting agents.

The polymeric dye transfer inhibiting agents are preferably selected from polyamine N-oxide polymers, copolymers of N-vinylpyrrolidone and N-vinylimidazole, polyvinylpyrrolidone polymers or combinations thereof.

#### a) Polyamine N-oxide polymers

Polyamine N-oxide polymers suitable for use herein contain units having the following structure formula :

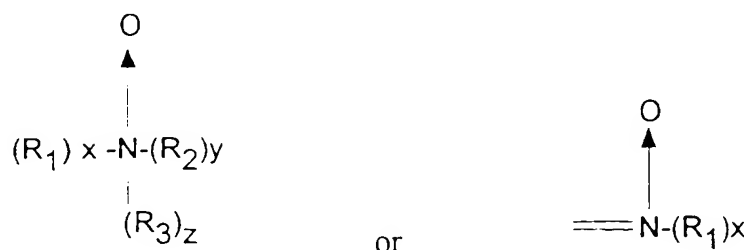


$\begin{array}{ccc} \text{O} & \text{O} & \text{O} \\ | & | & | \\ \vdots & \vdots & \vdots \end{array}$

A is NC, CO, C, -O-, -S-, -N-; x is 0 or 1;

R are aliphatic, ethoxylated aliphatics, aromatic, heterocyclic or alicyclic groups or any combination thereof where to the nitrogen of the N-O group can be attached or wherein the nitrogen of the N-O group is part of these groups.

The N-O group can be represented by the following general structures :



wherein R1, R2, and R3 are aliphatic groups, aromatic, heterocyclic or alicyclic groups or combinations thereof, x or/and y or/and z is 0 or 1 and wherein the nitrogen of the N-O group can be attached or wherein the nitrogen of the N-O group forms part of these groups. The N-O group can be part of the polymerisable unit (P) or can be attached to the polymeric backbone or a combination of both.

Suitable polyamine N-oxides wherein the N-O group forms part of the polymerisable unit comprise polyamine N-oxides wherein R is selected from aliphatic, aromatic, alicyclic or heterocyclic groups. One class of said polyamine N-oxides comprises the group of polyamine N-oxides wherein the nitrogen of the N-O group forms part of the R-group. Preferred polyamine N-oxides are those wherein R is a heterocyclic group such as pyrridine, pyrrole, imidazole, pyrrolidine, piperidine, quinoline, acridine and derivatives thereof.

polyamine N-oxides comprises the polyamine N-oxides having the general

formula (I) wherein R is an aromatic, heterocyclic or alicyclic groups wherein the nitrogen of the N-O functional group is part of said R group. Examples of these classes are polyamine oxides wherein R is a heterocyclic compound such as pyridine, pyrrole, imidazole and derivatives thereof.

The polyamine N-oxides can be obtained in almost any degree of polymerisation. The degree of polymerisation is not critical provided the material has the desired water-solubility and dye-suspending power. Typically, the average molecular weight is within the range of 500 to 1000,000.

#### b) Copolymers of N-vinylpyrrolidone and N-vinylimidazole

Suitable herein are copolymers of N-vinylimidazole and N-vinylpyrrolidone having an average molecular weight range of from 5,000 to 50,000. The preferred copolymers have a molar ratio of N-vinylimidazole to N-vinylpyrrolidone from 1 to 0.2.

#### c) Polyvinylpyrrolidone

The detergent compositions herein may also utilize polyvinylpyrrolidone ("PVP") having an average molecular weight of from 2,500 to 400,000. Suitable polyvinylpyrrolidones are commercially available from ISP Corporation, New York, NY and Montreal, Canada under the product names PVP K-15 (viscosity molecular weight of 10,000), PVP K-30 (average molecular weight of 40,000), PVP K-60 (average molecular weight of 160,000), and PVP K-90 (average molecular weight of 360,000). PVP K-15 is also available from ISP Corporation. Other suitable polyvinylpyrrolidones which are commercially available from BASF Cooperation include Sokalan HP 165 and Sokalan HP 12.

#### d) Polyvinylloxazolidone

The detergent compositions herein may also utilize polyvinylloxazolidone

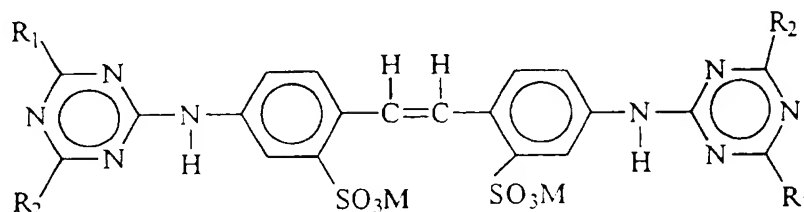
### e) Polyvinylimidazole

The detergent compositions herein may also utilize polyvinylimidazole as polymeric dye transfer inhibiting agent. Said polyvinylimidazoles preferably have an average molecular weight of from 2,500 to 400,000.

### Optical brightener

The detergent compositions herein also optionally contain from about 0.005% to 5% by weight of certain types of hydrophilic optical brighteners.

Hydrophilic optical brighteners useful herein include those having the structural formula:



wherein  $R_1$  is selected from anilino, N-2-bis-hydroxyethyl and NH-2-hydroxyethyl;  $R_2$  is selected from N-2-bis-hydroxyethyl, N-2-hydroxyethyl-N-methylamino, morpholino, chloro and amino; and M is a salt-forming cation such as sodium or potassium.

When in the above formula,  $R_1$  is anilino,  $R_2$  is N-2-bis-hydroxyethyl and M is a cation such as sodium, the brightener is 4,4',-bis[(4-anilino-6-(N-2-bis-hydroxyethyl)-s-triazine-2-yl)amino]-2,2'-stilbenedisulfonic acid and disodium salt. This particular brightener species is commercially marketed under the tradename Tinopal-UNPA-GX by Ciba-Geigy Corporation. Tinopal-UNPA-GX is the preferred hydrophilic optical brightener useful in the detergent compositions herein.

When in the above formula,  $R_1$  is anilino,  $R_2$  is N-2-hydroxyethyl-N-2-

yl)amino]2,2'-stilbenedisulfonic acid disodium salt. This particular brightener species is commercially marketed under the tradename Tinopal 5BM-GX by Ciba-Geigy Corporation.

When in the above formula, R<sub>1</sub> is anilino, R<sub>2</sub> is morphilino and M is a cation such as sodium, the brightener is 4,4'-bis[(4-anilino-6-morphilino-s-triazine-2-yl)amino]2,2'-stilbenedisulfonic acid, sodium salt. This particular brightener species is commercially marketed under the tradename Tinopal AMS-GX by Ciba Geigy Corporation.

#### Cationic fabric softening agents

Cationic fabric softening agents can also be incorporated into compositions in accordance with the present invention. Suitable cationic fabric softening agents include the water insoluble tertiary amines or dilong chain amide materials as disclosed in GB-A-1 514 276 and EP-B-0 011 340.

Cationic fabric softening agents are typically incorporated at total levels of from 0.5% to 15% by weight, normally from 1% to 5% by weight.

#### Other optional ingredients

Other optional ingredients suitable for inclusion in the compositions of the invention include colours and filler salts, with sodium sulfate being a preferred filler salt.

#### pH of the compositions

The present compositions preferably have a pH measured as a 1% solution in distilled water of at least 8.5, preferably from 9.0 to 12.5, most preferably from 9.5 to 11.0.

#### Form of the compositions

compositions are particularly the so-called concentrated granular detergent



compositions adapted to be added to a washing machine by means of a dispensing device placed in the machine drum with the soiled fabric load.

In general, granular detergent compositions in accordance with the present invention can be made via a variety of methods including dry mixing, spray drying, agglomeration and granulation.

The mean particle size of the components of granular compositions in accordance with the invention should preferably be such that no more than 5% of particles are greater than 1.7mm in diameter and not more than 5% of particles are less than 0.15mm in diameter.

The term mean particle size as defined herein is calculated by sieving a sample of the composition into a number of fractions (typically 5 fractions) on a series of Tyler sieves. The weight fractions thereby obtained are plotted against the aperture size of the sieves. The mean particle size is taken to be the aperture size through which 50% by weight of the sample would pass.

The bulk density of granular detergent compositions in accordance with the present invention typically have a bulk density of at least 600 g/litre, more preferably from 650 g/litre to 1200 g/litre. Bulk density is measured by means of a simple funnel and cup device consisting of a conical funnel moulded rigidly on a base and provided with a flap valve at its lower extremity to allow the contents of the funnel to be emptied into an axially aligned cylindrical cup disposed below the funnel. The funnel is 130 mm high and has internal diameters of 130 mm and 40 mm at its respective upper and lower extremities. It is mounted so that the lower extremity is 140 mm above the upper surface of the base. The cup has an overall height of 90 mm, an internal height of 87 mm and an internal diameter of 84 mm. Its nominal volume is 500 ml.

To carry out a measurement, the funnel is filled with powder by hand pouring, the flap valve is opened and powder allowed to overfill the cup.

The filled cup is then weighed and the value obtained for the weight

of powder doubled to provide a bulk density in g/litre. Replicate measurements are made as required.

#### Surfactant agglomerate particles

The cationic ester surfactant herein, preferably with additional surfactants, is preferably present in granular compositions in the form of surfactant agglomerate particles, which may take the form of flakes, prills, marumes, noodles, ribbons, but preferably take the form of granules. The most preferred way to process the particles is by agglomerating powders (e.g. aluminosilicate, carbonate) with high active surfactant pastes and to control the particle size of the resultant agglomerates within specified limits. Such a process involves mixing an effective amount of powder with a high active surfactant paste in one or more agglomerators such as a pan agglomerator, a Z-blade mixer or more preferably an in-line mixer such as those manufactured by Schugi (Holland) BV, 29 Chroomstraat 8211 AS, Lelystad, Netherlands, and Gebruder Lodige Maschinenbau GmbH, D-4790 Paderborn 1, Elsenerstrasse 7-9, Postfach 2050, Germany. Most preferably a high shear mixer is used, such as a Lodige CB (Trade Name).

A high active surfactant paste comprising from 50% by weight to 95% by weight, preferably 70% by weight to 85% by weight of surfactant is typically used. The paste may be pumped into the agglomerator at a temperature high enough to maintain a pumpable viscosity, but low enough to avoid degradation of the anionic surfactants used. An operating temperature of the paste of 50°C to 80°C is typical.

#### Laundry washing method

Machine laundry methods herein typically comprise treating soiled laundry with an aqueous wash solution in a washing machine having dissolved or dispensed therein an effective amount of a machine laundry detergent composition in accord with the invention. By an effective amount of the

product dosages and wash solution volumes commonly employed in conventional machine laundry methods.

In a preferred use aspect a dispensing device is employed in the washing method. The dispensing device is charged with the detergent product, and is used to introduce the product directly into the drum of the washing machine before the commencement of the wash cycle. Its volume capacity should be such as to be able to contain sufficient detergent product as would normally be used in the washing method.

Once the washing machine has been loaded with laundry the dispensing device containing the detergent product is placed inside the drum. At the commencement of the wash cycle of the washing machine water is introduced into the drum and the drum periodically rotates. The design of the dispensing device should be such that it permits containment of the dry detergent product but then allows release of this product during the wash cycle in response to its agitation as the drum rotates and also as a result of its contact with the wash water.

To allow for release of the detergent product during the wash the device may possess a number of openings through which the product may pass. Alternatively, the device may be made of a material which is permeable to liquid but impermeable to the solid product, which will allow release of dissolved product. Preferably, the detergent product will be rapidly released at the start of the wash cycle thereby providing transient localised high concentrations of product in the drum of the washing machine at this stage of the wash cycle.

Preferred dispensing devices are reusable and are designed in such a way that container integrity is maintained in both the dry state and during the wash cycle. Especially preferred dispensing devices for use with the composition of the invention have been described in the following patents; GB-B-2, 157, 717, GB-B-2, 157, 718, EP-A-0201376, EP-A-0288345 and EP-A-0288346. An article by J.Bland published in Manufacturing

type commonly known as the "granulette". Another preferred dispensing

device for use with the compositions of this invention is disclosed in PCT Patent Application No. WO94/11562.

Especially preferred dispensing devices are disclosed in European Patent Application Publication Nos. 0343069 & 0343070. The latter Application discloses a device comprising a flexible sheath in the form of a bag extending from a support ring defining an orifice, the orifice being adapted to admit to the bag sufficient product for one washing cycle in a washing process. A portion of the washing medium flows through the orifice into the bag, dissolves the product, and the solution then passes outwardly through the orifice into the washing medium. The support ring is provided with a masking arrangement to prevent egress of wetted, undissolved, product, this arrangement typically comprising radially extending walls extending from a central boss in a spoked wheel configuration, or a similar structure in which the walls have a helical form.

Alternatively, the dispensing device may be a flexible container, such as a bag or pouch. The bag may be of fibrous construction coated with a water impermeable protective material so as to retain the contents, such as is disclosed in European published Patent Application No. 0018678.

Alternatively it may be formed of a water-insoluble synthetic polymeric material provided with an edge seal or closure designed to rupture in aqueous media as disclosed in European published Patent Application Nos. 0011500, 0011501, 0011502, and 0011968. A convenient form of water frangible closure comprises a water soluble adhesive disposed along and sealing one edge of a pouch formed of a water impermeable polymeric film such as polyethylene or polypropylene.

#### Packaging for the compositions

Commercially marketed executions of the bleaching compositions can be packaged in any suitable container including those constructed from paper, cardboard, plastic materials and any suitable laminates. A preferred packaging execution is described in European Application No

### Abbreviations used in Examples

In the detergent compositions, the abbreviated component identifications have the following meanings:

LAS	:	Sodium linear C <sub>12</sub> alkyl benzene sulfonate
TAS	:	Sodium tallow alkyl sulfate
C45AS	:	Sodium C <sub>14</sub> -C <sub>15</sub> linear alkyl sulfate
C <sub>x</sub> yEzS	:	Sodium C <sub>1x</sub> -C <sub>1y</sub> branched alkyl sulfate condensed with z moles of ethylene oxide
C45E7	:	A C <sub>14-15</sub> predominantly linear primary alcohol condensed with an average of 7 moles of ethylene oxide
C25E3	:	A C <sub>12-15</sub> branched primary alcohol condensed with an average of 3 moles of ethylene oxide
C25E5	:	A C <sub>12-15</sub> branched primary alcohol condensed with an average of 5 moles of ethylene oxide
CEQ I	:	R <sub>1</sub> COOCH <sub>2</sub> CH <sub>2</sub> .N <sup>+</sup> (CH <sub>3</sub> ) <sub>3</sub> with R <sub>1</sub> = C <sub>11</sub> -C <sub>13</sub>
CEQ II	:	R <sub>1</sub> COOCH <sub>2</sub> CH <sub>2</sub> CH <sub>2</sub> N <sup>+</sup> (CH <sub>3</sub> ) <sub>3</sub> with R <sub>1</sub> = C <sub>11</sub> -C <sub>13</sub>
CEQ III	:	R <sub>1</sub> COOCH <sub>2</sub> CH <sub>2</sub> N <sup>+</sup> (CH <sub>3</sub> ) <sub>2</sub> (CH <sub>2</sub> CH <sub>2</sub> OH) with R <sub>1</sub> =C <sub>11</sub> -C <sub>13</sub>
CEQ IV	:	R <sub>1</sub> COOCH <sub>2</sub> CH <sub>2</sub> N <sup>+</sup> (CH <sub>3</sub> CH <sub>2</sub> ) <sub>2</sub> (CH <sub>3</sub> ) with R <sub>1</sub> =C <sub>11</sub> -C <sub>13</sub>
QAS I	:	R <sub>2</sub> .N <sup>+</sup> (CH <sub>3</sub> ) <sub>2</sub> (C <sub>2</sub> H <sub>4</sub> OH) with R <sub>2</sub> = C <sub>12</sub> - C <sub>14</sub>
QAS II	:	R <sub>2</sub> .N <sup>+</sup> (CH <sub>3</sub> ) <sub>2</sub> (C <sub>2</sub> H <sub>4</sub> OH) with R <sub>2</sub> = C <sub>8</sub> - C <sub>10</sub>
Soap	:	Sodium linear alkyl carboxylate derived from an 80/20 mixture of tallow and coconut oils.
TFAA	:	C <sub>16</sub> -C <sub>18</sub> alkyl N-methyl glucamide
TPKFA	:	C <sub>12</sub> -C <sub>14</sub> topped whole cut fatty acids
STPP	:	Anhydrous sodium tripolyphosphate
Zeolite A	:	Hydrated Sodium Aluminosilicate of formula Na <sub>12</sub> (AlO <sub>2</sub> SiO <sub>2</sub> ) <sub>12</sub> . 27H <sub>2</sub> O having a primary particle size in the range from 0.1 to 10

Citric acid	:	Anhydrous citric acid
Carbonate	:	Anhydrous sodium carbonate with a particle size between 200 $\mu$ m and 900 $\mu$ m
Bicarbonate	:	Anhydrous sodium bicarbonate with a particle size distribution between 400 $\mu$ m and 1200 $\mu$ m
Silicate	:	Amorphous Sodium Silicate (SiO <sub>2</sub> :Na <sub>2</sub> O; 2.0 ratio)
Sodium sulfate	:	Anhydrous sodium sulfate
Citrate	:	Tri-sodium citrate dihydrate of activity 86.4%
with		a particle size distribution between 425 $\mu$ m and q
850		$\mu$ m
MA/AA	:	Copolymer of 1:4 maleic/acrylic acid, average molecular weight about 70,000.
CMC	:	Sodium carboxymethyl cellulose
Protease	:	Proteolytic enzyme of activity 4KNPU/g sold by NOVO Industries A/S under the tradename Savinase
Alcalase	:	Proteolytic enzyme of activity 3AU/g sold by NOVO Industries A/S
Cellulase	:	Cellulytic enzyme of activity 1000 CEVU/g sold by NOVO Industries A/S under the tradename Carezyme
Amylase	:	Amylolytic enzyme of activity 60KNU/g sold by NOVO Industries A/S under the tradename Termamyl 60T
Lipase	:	Lipolytic enzyme of activity 100kLU/g sold by NOVO Industries A/S under the tradename Lipolase
Endolase	:	Endoglunase enzyme of activity 3000 CEVU/g sold by NOVO Industries A/S
PB4	:	Sodium perborate tetrahydrate of nominal formula NaBO <sub>2</sub> .3H <sub>2</sub> O.H <sub>2</sub> O <sub>2</sub>
PB1	:	Anhydrous sodium perborate bleach of nominal formula NaBO <sub>2</sub> .H <sub>2</sub> O <sub>2</sub>

NOBS	:	Nonanoyloxybenzene sulfonate in the form of the sodium salt
NAC-OBS	:	(Nonanamido caproyl) oxybenzene sulfonate in the form of the sodium salt.
NACA	:	6 nonylamino - 6 oxo - capronic acid.
TAED	:	Tetraacetythylenediamine
DTPMP	:	Diethylene triamine penta (methylene phosphonate), marketed by Monsanto under the Trade name Dequest 2060
Photoactivated bleach	:	Sulfonated Zinc Phthlocyanine encapsulated in dextrin soluble polymer
Brightener 1	:	Disodium 4,4'-bis(2-sulphostyryl)biphenyl
Brightener 2	:	Disodium 4,4'-bis(4-anilino-6-morpholino-1.3.5-triazin-2-yl)amino) stilbene-2:2'-disulfonate.
HEDP	:	1,1-hydroxyethane diphosphonic acid
PVNO	:	Polyvinylpyridine N-oxide
PVPVI	:	Copolymer of polyvinylpyrrolidone and vinylimidazole
SRP 1	:	Sulfobenzoyl end capped esters with oxyethylene oxy and terephthaloyl backbone
SRP 2	:	Diethoxylated poly (1, 2 propylene terephthalate) short block polymer
Silicone antifoam	:	Polydimethylsiloxane foam controller with siloxane-oxyalkylene copolymer as dispersing agent with a ratio of said foam controller to said dispersing agent of 10:1 to 100:1.

In the following Examples all levels are quoted as % by weight of the composition:

**Example 1**

The following laundry detergent compositions A to F are examples in accord with the invention:

	A	B	C	D	E	F
LAS	8.0	8.0	8.0	8.0	8.0	8.0
C25E3	3.4	3.4	3.4	3.4	3.4	3.4
CEQ I	0.2	0.8	1.0	2.0	1.0	0.7
CEQ II	-	0.5	0.5	0.7	2.0	0.8
QAS I	-	-	0.8	-	-	0.8
QAS II	0.8	-	-	-	-	-
Zeolite A	18.1	18.1	18.1	18.1	18.1	18.1
Carbonate	13.0	13.0	13.0	27.0	27.0	27.0
Silicate	1.4	1.4	1.4	3.0	3.0	3.0
Sodium sulfate	26.1	26.1	26.1	26.1	26.1	26.1
PB4	9.0	9.0	9.0	9.0	9.0	9.0
NAC OBS	2.5	1.5	3.0	4.0	3.2	2.2
DETPMP	0.25	0.25	0.25	0.25	0.25	0.25
HEDP	0.3	0.3	0.3	0.3	0.3	0.3



Amylase	0.1	0.1	0.1	0.1	0.1	0.1
MA/AA	0.3	0.3	0.3	0.3	0.3	0.3
CMC	0.2	0.2	0.2	0.2	0.2	0.2
Photoactivated bleach (ppm)	15 ppm	15 ppm	15 ppm	15 ppm	15 ppm	15 ppm
Brightener 1	0.09	0.09	0.09	0.09	0.09	0.09
Perfume	0.3	0.3	0.3	0.3	0.3	0.3
Silicone antifoam	0.5	0.5	0.5	0.5	0.5	0.5
Misc/minors to 100%						
Density in g/litre	850	850	850	850	850	850

**Example 2**

The following granular laundry detergent compositions G to I of bulk density 750 g/litre are examples in accord with the invention:

	G	H	I
LAS	5.25	5.61	4.76
TAS	1.25	1.86	1.57
C45AS	-	2.24	3.89
C25AE3S	-	0.76	1.18
C45E7	3.25	-	5.0
C25E3	-	5.5	-
CEQ II	0.8	2.0	2.0
CEQ III	0.4	1.0	0.5
STPP	19.7	-	-
Zeolite A	-	19.5	19.5
NaSKS-6/citric acid (79:21)	-	10.6	10.6
Carbonate	6.1	21.4	21.4
Bicarbonate	-	2.0	2.0
Silicate	6.8	-	-

PB4	5.0	12.7	-
TAED	0.5	1.6	-
NAC OBS	1.0	1.2	1.3
DETPMP	0.25	0.2	0.2
HEDP	-	0.3	0.3
Protease	0.26	0.85	0.85
Lipase	0.15	0.15	0.15
Cellulase	0.28	0.28	0.28
Amylase	0.1	0.1	0.1
MA/AA	0.8	1.6	1.6
CMC	0.2	0.4	0.4
Photoactivated bleach (ppm)	15 ppm	27 ppm	27 ppm
Brightener 1	0.08	0.19	0.19
Brightener 2	-	0.04	0.04
Perfume	0.3	0.3	0.3
Silicone antifoam	0.5	2.4	2.4
Minors/misc to 100%			

**Example 3**

The following detergent formulations are examples according to the present invention where J is a phosphorus-containing detergent composition, K is a zeolite-containing detergent composition and L is a compact detergent composition:

	J	K	L
Blown Powder			
STPP	19.0	-	19.0
Zeolite A	-	24.0	-
C45AS	9.0	6.0	13.0
CEQ I	-	2.0	-
CEQ II	-	-	2.0
CEQ III	2.0	-	-
MA/AA	1.5	1.2	1.2
LAS	6.0	7.8	11.0
TAS	2.0	-	-
Silicate	7.0	3.0	3.0
CMC	1.0	1.0	0.5
Brightener 2	0.2	0.2	0.2
Soap	1.0	1.0	1.0
DTPMP	0.4	0.4	0.2
Spray On			
C45E7	2.5	2.5	2.0
C25E3	2.5	2.5	2.0
Silicone antifoam	0.3	0.3	0.3
Perfume	0.3	0.3	0.3
Dry additives			
Carbonate	6.0	13.0	15.0
PB4	18.0	18.0	10.0
PB1	4.0	4.0	0
NAC OBS	3.0	4.2	1.0
Photoactivated bleach	0.02	0.02	0.02
Amylase	0.25	0.30	0.15

Dry mixed sodium sulfate	3.0	3.0	5.0
Balance (Moisture & Miscellaneous)	100.0	100.0	100.0
Density (g/litre)	630	670	670

**Example 4**

The following detergent formulations are examples according to the present invention:

	P	Q	R	S
LAS	20.0	6.0	24.0	22.0
QAS I	0.7	1.0	-	0.7
CEQ III	0.4	0.4	2.2	1.5
CEQ IV	1.5	0.4	1.0	1.5
TFAA	-	1.0	-	-
C25E5/C45E7	-	6.5	-	0.5
C45E3S	-	7.5	-	-
STPP	30.0	9.0	30.0	22.0
Silicate	9.0	5.0	10.0	8.0
Carbonate	13.0	7.5	-	5.0
Bicarbonate	-	7.5	-	-
DTPMP	0.7	1.0	-	-
SRP I	0.3	0.2	-	0.1
MA/AA	1.0	1.5	1.0	1.0
CMC	0.8	0.4	0.4	0.2
Protease	0.8	1.0	0.5	0.5
Amylase	0.8	0.4	-	0.25
Lipase	0.2	0.1	0.2	0.1
Cellulase	0.15	0.05	-	-
Photoactivated bleach (ppm)	70ppm	45ppm	-	10ppm
Brightener I	0.2	0.2	0.08	0.2
PBI	6.0	2.0	-	-
NAC OBS	2.0	1.0	0.9	3.1
Balance (Moisture and Miscellaneous)	100	100	100	100

**Example 5**

The following detergent formulations are examples according to the present invention:

	T	U	V
Blown Powder			
CEQ II	-	0.4	1.5
CEQ IV	0.8	0.8	1.5
Zeolite A	30.0	22.0	6.0
Sodium sulfate	19.0	5.0	7.0
MA/AA	1.5	1.5	1.2
LAS	14.0	12.0	22.0
C45AS	7.0	7.0	7.0
Silicate	-	1.0	5.0
Soap	-	-	2.0
Brightener I	0.2	0.2	0.2
Carbonate	8.0	16.0	20.0
Spray On			
C45E7	1.0	1.0	1.0
Dry additives			
PVPVI/PVNO	0.5	0.5	0.5
Protease	1.0	1.0	1.0
Lipase	0.4	0.4	0.4
Amylase	0.1	0.1	0.1
Cellulase	0.1	0.1	0.1
NACA	3.4	6.1	4.5
Sodium sulfate	-	6.0	-
Balance (Moisture and Miscellaneous)	100	100	100

**Example 6**

The following high density and bleach-containing detergent formulations are examples according to the present invention:

	W	X	Y
Blown Powder			
Zeolite A	15.0	15.0	15.0
Sodim sulfate	0.0	5.0	0.0
LAS	3.0	3.0	3.0
QAS	-	1.5	1.5
CEQ II	0.2	0.5	2.4
CEQ III	0.3	0.9	-
DTPMP	0.4	0.4	0.4
CMC	0.4	0.4	0.4
MA/AA	1.3	1.7	1.7
Agglomerates			
LAS	5.0	5.0	5.0
TAS	2.0	2.0	1.0
Silicate	3.0	3.0	4.0
Zeolite A	8.0	8.0	8.0
Carbonate	8.0	8.0	4.0
Spray On			
Perfume	0.3	0.3	0.3
C45E7	2.0	2.0	2.0
C25E3	2.0	-	-
Dry additives			
Citrate	5.0	-	2.0
Bicarbonate	-	3.0	-
Carbonate	8.0	15.0	10.0
NAC OBS	6.0	2.0	5.0
NACA	2.0	1.8	1.2
PBI	14.0	7.0	10.0
Polyethylene oxide of MW	-		0.2
Protease	1.0	1.0	1.0



Lipase	0.4	0.4	0.4
Amylase	0.6	0.6	0.6
Cellulase	0.6	0.6	0.6
Silicone antifoam	5.0	5.0	5.0
Dry additives			
Sodium sulfate	0.0	3.0	0.0
Balance (Moisture and Miscellaneous)	100.0	100.0	100.0
Density (g/litre)	850	850	850

**Example 7**

The following high density detergent formulations are examples according to the present invention:

	Z	AA
Agglomerate		
C45AS	11.0	14.0
CEQ III	0.6	1.1
Zeolite A	15.0	6.0
Carbonate	4.0	8.0
MA/AA	1.3	2.0
CMC	0.5	0.5
DTPMP	0.4	0.4
Spray On		
C25E5	5.0	5.0
Perfume	0.5	0.5
Dry Adds		
HEDP	0.5	0.3
SKS 6	13.0	10.0
Citrate	3.0	1.0
NAC OBS	4.1	6.2
TAED	1.6	1.7
Percarbonate	20.0	20.0
SRP 1	0.3	0.3
Protease	1.4	1.4
Lipase	0.4	0.4
Cellulase	0.6	0.6
Amylase	0.6	0.6
Silicone antifoam	5.0	5.0
Brightener 1	0.2	0.2
Brightener 2	0.2	-
Balance (Moisture and	100	100

**Example 8**

The following liquid detergent formulations are examples according to the present invention:

	AB	AC	AD	AE	AF	AG	AH	AI
CEQ I	0.4	1.0	0.8	0.4	2.0	2.5	-	3.5
CEQ II	0.6	1.2	0.7	0.4	1.2	-	3.5	-
LAS	10.0	13.0	9.0	-	25.0	-	-	-
C25AS	4.0	1.0	2.0	10.0	-	13.0	18.0	15.0
C25E3S	1.0	-	-	3.0	-	2.0	2.0	4.0
C25E7	6.0	8.0	13.0	2.5	-	-	4.0	4.0
TFAA	-	-	-	4.5	-	6.0	8.0	8.0
QAS	-	-	-	-	3.0	1.0	-	-
MA/AA	1.6	1.4	1.0	0.6	1.2	0.9	0.4	1.4
TPKFA	2.0	-	13.0	2.0	-	15.0	7.0	7.0
Rapeseed fatty acids	-	-	-	5.0	-	-	4.0	4.0
Citric acid	2.0	3.0	1.0	1.5	1.0	1.0	1.0	1.0
Dodecenyl/tetradecenyl succinic acid	12.0	10.0	-	-	15.0	-	-	-
Oleic acid	4.0	2.0	1.0	-	1.0	-	-	-
Ethanol	4.0	4.0	7.0	2.0	7.0	2.0	3.0	2.0
1,2 Propanediol	4.0	4.0	2.0	7.0	6.0	8.0	10.0	13.-
Mono Ethanol Amine	-	-	-	5.0	-	-	9.0	9.0
Tri Ethanol Amine	-	-	8	-	-	-	-	-
NaOH up to pH	8.0	8.0	7.6	7.7	8.0	7.5	8.0	8.2
Ethoxylated tetraethylene pentamine	0.5	-	0.5	0.2	-	-	0.4	0.3
NAC OBS	1.0	1.0	0.5	1.0	2.0	1.2	1.0	1.6
NACA	0.7	1.1	1.8	1.5	1.9	2.1	1.4	1.0
PB <sub>4</sub>	2.0	2.6	3.1	3.0	3.1	3.5	2.9	2.5
SRP 2	0.3	-	0.3	0.1	-	-	0.2	0.1
PVNO	-	-	-	-	-	-	-	0.10
Protease	0.5	0.5	0.4	0.25	-	0.5	0.3	0.6

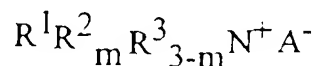
Amylase

Cellulase	-	-	-	0.05	-	-	0.15	0.15
Endolase	-	-	-	0.10	-	-	0.07	-
Boric acid	0.1	0.2	-	2.0	1.0	1.5	2.5	2.5
Na formate	-	-	1.0	-	-	-	-	-
Ca chloride	-	0.015	-	0.01	-	-	-	-
Bentonite clay	-	-	-	-	4.0	4.0	-	-
Suspending clay SD3	-	-	-	-	0.6	0.3	-	-
Balance (Moisture and Miscellaneous)	100	100	100	100	100	100	100	100

## CLAIMS

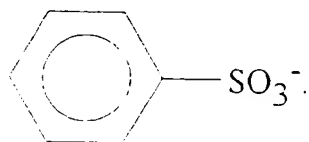
1. A detergent composition comprising a hard acid cationic component and up to 1.7% by weight total detergent composition of hard base polymeric component, and wherein the ratio of hard acid cationic component to hard base polymeric component is from 10:1 to 1:3, the composition comprising less than 20% by weight phosphate component.
2. A detergent composition according to claim 1 wherein the hard acid cationic component is present in an amount below 1.5%.
3. A detergent composition according to claim 1 or claim 2 comprising no greater than 25% by weight sodium sulphate.
4. A detergent composition according to any preceding claim additionally comprising a bleach precursor compound, the amount of bleach precursor in the composition being at least 1.5% by weight when the bleach precursor is a hydrophilic bleach precursor.
5. A detergent composition according to claim 4 or claim 5 wherein the hydrophilic bleach precursor is tetracetylenethylenediamine.
7. A detergent composition according to any preceding claim comprising less than 8% by weight of sodium linear C<sub>12</sub> alkyl benzene sulfonate.
8. A detergent composition according to any preceding claim wherein the hard base polymer component is present in amounts from 0.01% to 1.4% by weight.
9. A detergent composition according to any preceding claim wherein said hard acid cationic component comprises a quaternary ammonium compound.

10. A detergent composition according to any preceding claim wherein the hard acid cationic component comprises a cationic surfactant of the formula:



wherein  $R^1$  represents a  $C_{6-24}$  alkyl or alkenyl group or a  $C_{6-12}$  alkaryl group, each  $R^2$  independently represents a  $(C_n H_{2n} O)_x R^4$  group where  $n$  is 1 to 4 and  $x$  is from 1 to 14 and  $R^4$  represents hydrogen (preferred), methyl or ethyl, the sum total of  $C_n H_{2n} O$  groups is  $R_m^2$  being from 1 to 14, each  $R^3$  group independently represents a  $C_{1-12}$  alkyl or alkenyl group, an aryl group or a  $C_{1-6}$  alkaryl group,  $m$  is 1, 2 or 3, and  $A$  is a counterion providing electrical neutrality.

11. A detergent composition according to claim 10 wherein  $R^2$  is  $-CH_2CH_2OH$ ,  $R^3$  is (independently)  $C_{1-4}$  alkyl,  $m$  is 1 or 2 and  $R^1$  is a linear  $C_{6-14}$  alkyl group.
12. A detergent composition according to any preceding claim wherein the polymeric component comprises a pendant group which is a harder base than



13. A detergent composition according to any preceding claim wherein the hard base polymeric component comprises a polymer having pendant carboxylic functionality.
14. A detergent composition according to claim 13 wherein said hard base polymeric component comprises an acrylic, maleic or succinic polymer

15. A detergent composition according to any preceding claim wherein said hard base polymeric component has a molecular weight of from 2000 to 150,000.
16. A method of washing laundry in a domestic washing machine in which a dispensing device containing an effective amount of a solid detergent composition according to any of claims 1 to 9 is introduced into the drum of the washing machine before the commencement of the wash, wherein said dispensing device permits progressive release of said detergent composition into the wash liquor during the wash.



Application No: GB 9621799.7  
Claims searched: 1 to 16

Examiner: Michael Conlon  
Date of search: 30 January 1997

**Patents Act 1977**  
**Search Report under Section 17**

**Databases searched:**

UK Patent Office collections, including GB, EP, WO & US patent specifications, in:

UK CI (Ed.O): C5D (DHC, DHD, DHE, DHZ, DJA, DJX)

Int CI (Ed.6): C11D

Other: Online: WPI

**Documents considered to be relevant:**

Category	Identity of document and relevant passage	Relevant to claims
X	EP0495554 A1 (Procter & Gamble) page 10 lines 8 to 10 and page 8 lines 21 to 46, Examples III and V	1 at least
X	US4724090 (Lion)	1 at least.

Documents indicating lack of inventive step are compared with one or more other documents of same category

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Documents indicating lack of inventive step are compared with one or more other documents of same category  
Document published on or after the declared priority date but before the filing date of this invention

E Patent document published on or after, but with priority date earlier than, the filing date of this application